

Work Order ID 51925

Wednesday, September 09, 2009 11:36:04 A



Page 1

Item ID: D3564-5 GY	Accept		Setup Start	
Revision ID: D			Stop	
Item Name: Wearshoe				
Start Date: 9/11/2009	Start Qty: 10.00		Cust Item ID:	
Required Date: 9/18/2009	Req'd Qty: 10.00		Customer:	
Reference:				

Approvals:	Process Plan: RL MK	Date: 09-9-09	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100
 FLOW WATER JET 0.00
 Waterjet
 FLOW CNC Waterjet **304 .063** Memo 0.00
 1-Cut as per Dwg D3564 ☒ Dwg Rev: **D** ☐ Prog Rev: **D** ☐ 2-
 Deburr if necessary

IB 9-9-23

(11)

110
 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00
 Quality Control

IB 9-9-23

120
 QC8- Inspect parts - second check 0.00
 QC Memo 0.00
 Quality Control

27 8/20/12

(416)

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Page 2

Item ID: D3564-5

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 9/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

809/09/24

11

Ø

Brake NC

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT8157

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

809/09/24

Ø

Ø

Quality Control

Ensure joggle as per dwg D3429

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Powdercoat

Memo

0.00

M109091

Powder Coating

START TIME: 320 OF 320 ☐ OVEN TEMPERATURE: 12:58 ☐ FINISH TIME: 1:28

M-L 09/09/25

Ø

Work Order ID 51925

Wednesday, September 09, 2009 11:36:04 A

Page 3

Item ID: D3564-5

Accept

Setup Start

Revision ID: D

Stop

Item Name: Wearshoe

Start Date: 9/11/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 0905-25

170

Identify as per dwg & Stock Location: FP19 0.00

Packaging

Memo

0.00

Packaging

m. k o a l o a l a s (11x)

180

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/09/28

09-09-28

Picklist Print

Wednesday, September 09, 2009 11:36:10 AM

Page 1

Work Order ID: 51925



Parent Item: D3564-5RevD



Parent Item Name: Wearshoe



Start Date: 9/11/2009

Required Date: 9/18/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	261.2310	15.7895	17.3684		
												
304/316 Sheet .063											18 9-9-03	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

261.2309737

106860

16.018

111924

33.0549737

112290

36.8947

112442

79.2633

112567

96

112290

DART AEROSPACE LTD		Work Order:	5125
Description: Wearshoe		Part Number:	D3564-5
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

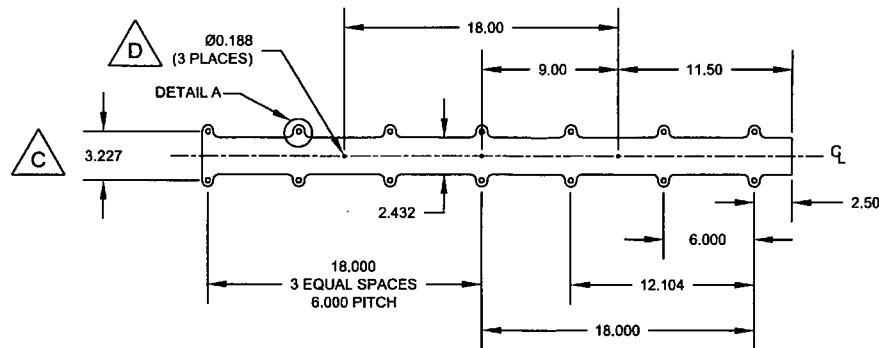
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.50	+/-0.030	43.50	X			
6.75	+/-0.030	6.75	*			
10.00	+/-0.030	10.00	X			
20.00	+/-0.030	20.00	*			
30.00	+/-0.030	30.00	X			
2.50	+/-0.030	2.501	X			
3.227	+/-0.010	3.225	X			
38.500	+/-0.010	38.500	*			
5.500	+/-0.010	5.500	X			
2.50	+/-0.030	2.501	X			
2.432	+/-0.010	2.431	X			
0.300 x 0.300	+/-0.010	304 x 306	*			
Ø0.188	+0.005/-0.001	.193	X			
R0.375	+/-0.010	.375	X			
0.063	+/-0.010	.062	X			

Measured by:	IB
Date:	9-9-23

Audited by:	C
Date:	01/01/23

Prototype Approval:	N/A
Date:	N/A

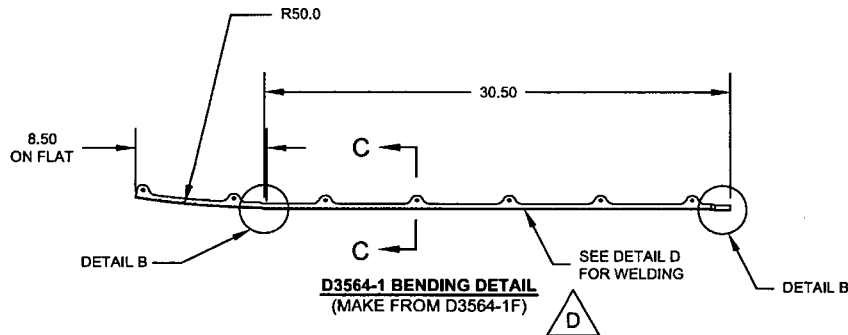
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DB	DD



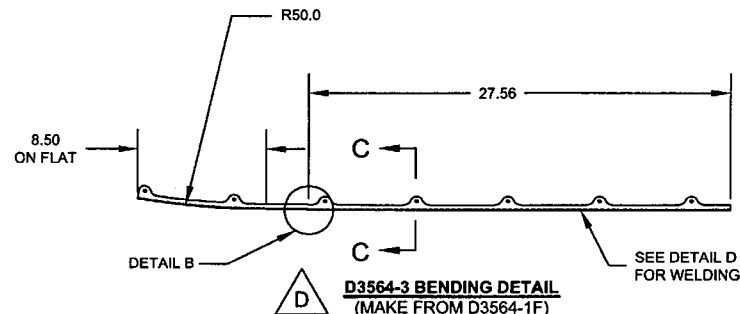
D3564-1F FLAT PATTERN

RELEASED

07.09.04



**D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)**



**D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51925

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

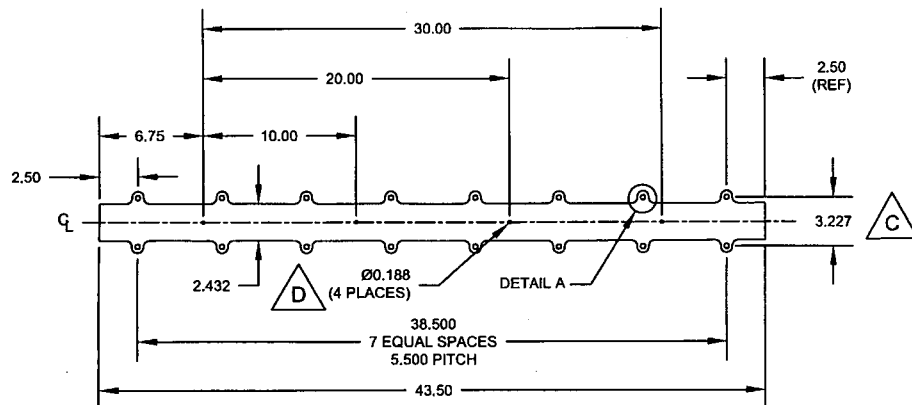
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B8, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

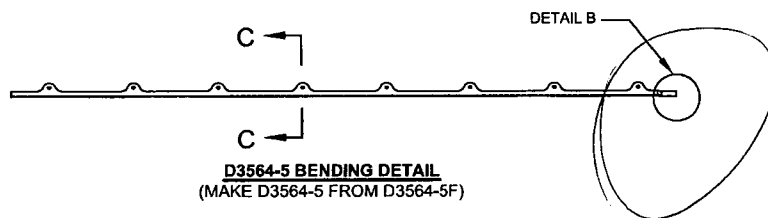
DRAWING NO. REV. D
D3564 SHEET 1 OF 3
TITLE SCALE
WEARSHOE 1:8

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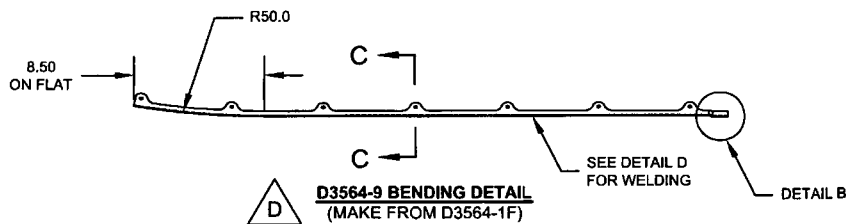
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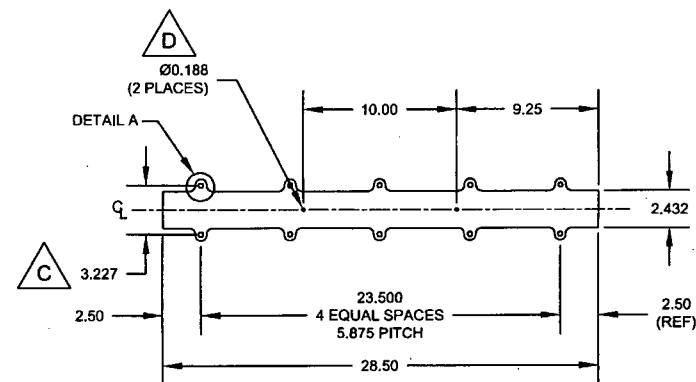
D3564-5F FLAT PATTERN



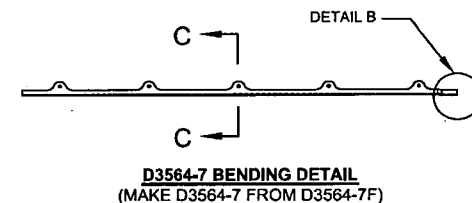
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



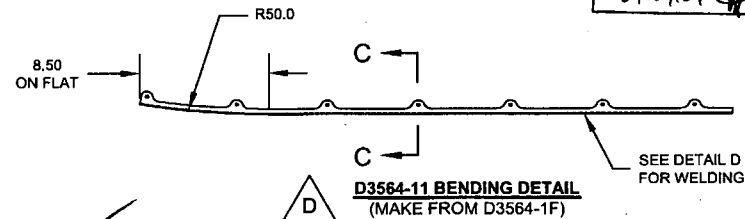
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

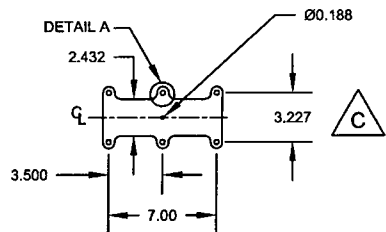
RELEASED

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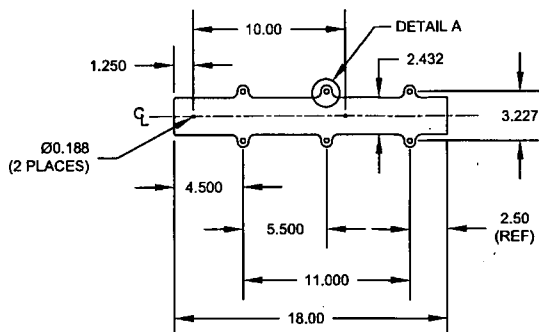
57925

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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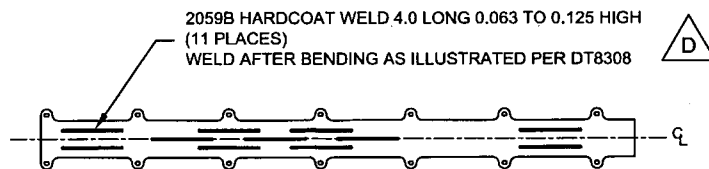
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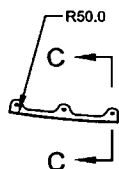
D3564-13F FLAT PATTERN



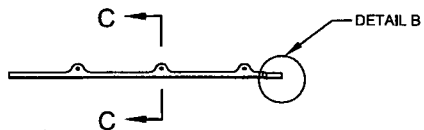
D3564-15F FLAT PATTERN



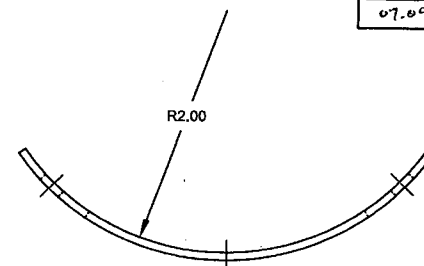
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



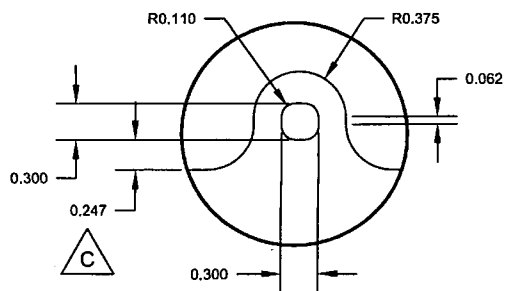
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



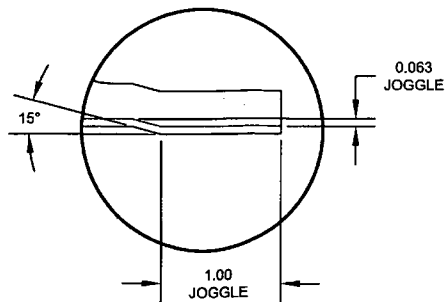
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

RELEASED

07.09.04

51925

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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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8 7 6 5 4 3 2 1